



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5549-3
Job Sheet 170802



Part No: D5549-3

Job Qty: 2 ea

Part Name: Aft Beam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/19/18

Job Tracking No:

Due Date: 2/26/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG D5549 REV.B SHEETS 7, 8 IPP REV:A 17.09.01 NEW ISSUE DD VERF:DP IPP REV:B 18.01.17 AS
PER DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		2/23/18	0.00	0.00	Start Up Waterjet		OK 18/02/21
100	Waterjet	2 pcs		2/23/18	0.00	4.13	Waterjet1		OK 18/02/21
110	QC	2 pcs		2/23/18	0.00	0.00	QC2 Waterjet-4		OK 18/02/21
120	CNC Vertical Machining	2 pcs		2/24/18	0.00	8.66	HAAS1-4		
130	QC	2 pcs		2/24/18	0.00	0.00	QC2 Machining-4		18/4/10/504
140	QC	2 pcs		2/24/18	0.00	0.00	QC8 Machining-4		18-04-12
150	HandFinish	2 pcs		2/24/18	0.00	1.14	HandFinish1		SA 18-04-16
160	QC	2 pcs		2/24/18	0.00	0.00	QC7-5		BR 18-04-17
170	Powdercoat	2 pcs		2/26/18	0.00	0.22	Powdercoat1		BR 18-04-17
180	QC	2 pcs		2/26/18	0.00	0.00	QC3		11 APR 23 2018
190	Packaging	2 pcs		2/26/18	0.00	0.00	Packaging3-2		APR 23 2018
200	QC21-SA	2 Ea		2/26/18	0.00	0.00	QC21		APR 23 2018

Part Op 100 - 1-Cut contour and pockets as per Dwg Dwg Rev: B Prog Rev: B 2-Debur if necessary

Descriptions: 120 - Drill holes as per dwg manually on Hass4 Dwg rev: B

170 - ***Mask holes or blow out access powdercoat in holes*** START TIME: 1:15 OVEN TEMPERATURE: 270° FINISH TIME: 1:45 M 18/04/18

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X8.000	6061T6 Bar 1.000 X 8.000	9.1600 ft (4.58 ea)	90-Start up Operation	5042203

Part Specifications

Specifications could not be found.

Plex 1/19/18 1:08 PM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS																																																																																																																															
Part No. _____		Rework ☐		Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐																																																																																																																									
NCR No. _____		Scrap ☐		Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐		Quality ☐																																																																																																																									
		Use-as-is ☐		Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐		Other ☐																																																																																																																									
		Suspected Unapproved ☐		Large Fab ☐		Composite ☐		Supplier ☐																																																																																																																											
Date : _____		Step #: _____		Part: D5549-3 Job No: 170802 Serial No/Batch: S044562 Revision: D5549 Inspector: _____ Date: 02/22/18 Container No: S044562 Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 813 632-6200 Email: sales@dartaero.com www.dartaerospace.com						MRB (QSI042) Approval																																																																																																																									
Description Work Order Deviation		Completed By																																																																																																																																	
		Lead hand / Supervisor Approval Verification																																																																																																																																	
		QC / QA Coordinator Approval																																																																																																																																	
<table border="1"> <tr> <td colspan="4">Root</td> <td colspan="4"></td> <td colspan="4"></td> </tr> <tr> <td>Environment</td><td>☐</td> <td>Power Loss/Surge</td><td>☐</td> <td>Positioned Wrong</td><td>☐</td> <td>Design</td><td>☐</td> <td>olio/Program</td><td>☐</td> <td>Outside Dimensions</td><td>☐</td> </tr> <tr> <td>Doc/Data</td><td>☐</td> <td>rain</td><td>☐</td> <td>Over/Under tolerance</td><td>☐</td> <td>Equip/Tooling</td><td>☐</td> <td>Weld</td><td>☐</td> <td>Part Incorrect</td><td>☐</td> </tr> <tr> <td>Handling/Pre</td><td>☐</td> <td>Wrong Stock Pulled</td><td>☐</td> <td>Part Lost/Missing</td><td>☐</td> <td>Material</td><td>☐</td> <td>Out of Sequence</td><td>☐</td> <td>Part Moved</td><td>☐</td> </tr> <tr> <td>Internal Transport</td><td>☐</td> <td>Off-set</td><td>☐</td> <td>Drawing</td><td>☐</td> <td>Contamination</td><td>☐</td> <td>Mislabeled</td><td>☐</td> <td>Finish</td><td>☐</td> </tr> <tr> <td>Tribal Knowledge</td><td>☐</td> <td>Misaligned/off center</td><td>☐</td> <td>Misread</td><td>☐</td> <td>Countersink</td><td>☐</td> <td>Fit/Function</td><td>☐</td> <td>Turning Sequence</td><td>☐</td> </tr> <tr> <td>LOA</td><td>☐</td> <td></td><td>☐</td> <td></td><td>☐</td> <td>Cut Too Short</td><td>☐</td> <td></td><td>☐</td> <td></td><td>☐</td> </tr> <tr> <td>Substation</td><td>☐</td> <td></td><td>☐</td> <td></td><td>☐</td> <td>Instructions Incomplete/Unclear</td><td>☐</td> <td></td><td>☐</td> <td></td><td>☐</td> </tr> <tr> <td>Past Expiry Date</td><td>☐</td> <td></td><td>☐</td> <td></td><td>☐</td> <td>Drill Holes</td><td>☐</td> <td></td><td>☐</td> <td></td><td>☐</td> </tr> <tr> <td>Misidentified</td><td>☐</td> <td></td><td>☐</td> <td></td><td>☐</td> <td></td><td>☐</td> <td></td><td>☐</td> <td></td><td>☐</td> </tr> </table>												Root												Environment	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Design	☐	olio/Program	☐	Outside Dimensions	☐	Doc/Data	☐	rain	☐	Over/Under tolerance	☐	Equip/Tooling	☐	Weld	☐	Part Incorrect	☐	Handling/Pre	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Material	☐	Out of Sequence	☐	Part Moved	☐	Internal Transport	☐	Off-set	☐	Drawing	☐	Contamination	☐	Mislabeled	☐	Finish	☐	Tribal Knowledge	☐	Misaligned/off center	☐	Misread	☐	Countersink	☐	Fit/Function	☐	Turning Sequence	☐	LOA	☐		☐		☐	Cut Too Short	☐		☐		☐	Substation	☐		☐		☐	Instructions Incomplete/Unclear	☐		☐		☐	Past Expiry Date	☐		☐		☐	Drill Holes	☐		☐		☐	Misidentified	☐		☐		☐		☐		☐		☐
Root																																																																																																																																			
Environment	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Design	☐	olio/Program	☐	Outside Dimensions	☐																																																																																																																								
Doc/Data	☐	rain	☐	Over/Under tolerance	☐	Equip/Tooling	☐	Weld	☐	Part Incorrect	☐																																																																																																																								
Handling/Pre	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Material	☐	Out of Sequence	☐	Part Moved	☐																																																																																																																								
Internal Transport	☐	Off-set	☐	Drawing	☐	Contamination	☐	Mislabeled	☐	Finish	☐																																																																																																																								
Tribal Knowledge	☐	Misaligned/off center	☐	Misread	☐	Countersink	☐	Fit/Function	☐	Turning Sequence	☐																																																																																																																								
LOA	☐		☐		☐	Cut Too Short	☐		☐		☐																																																																																																																								
Substation	☐		☐		☐	Instructions Incomplete/Unclear	☐		☐		☐																																																																																																																								
Past Expiry Date	☐		☐		☐	Drill Holes	☐		☐		☐																																																																																																																								
Misidentified	☐		☐		☐		☐		☐		☐																																																																																																																								
OTHER : _____																																																																																																																																			

DART AEROSPACE LTD		Work Order: 170802
Description: AFT Beam		Part Number: D5549-3
Inspection Dwg: 5549	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.65	-.000 +.030	.654				
.50	-.000 +.030	.506				
7.23	+/- .030	7.23				
10.73	+/- .030	10.73				
11.23	+/- .030	11.23				
15.23	+/- .030	15.23				
19.23	+/- .030	19.23				
23.23	+/- .030	23.23				
27.23	+/- .030	27.23				
31.23	+/- .030	31.23				
35.23	+/- .030	35.23				
39.23	+/- .030	39.23				
43.23	+/- .030	43.23				
46.73	+/- .030	46.73				
1.25	+/- .030	1.25				
6.50	+/- .030	6.50				
1.06	+/- .030	1.06				
4.06	+/- .030	4.06				
1.00	+/- .010	1.006				
0.257"	+0.006"/-0.001	0.257"	✓		Vernier	CNC-19
0.377"	+ " / - "	0.378"	✓		"	" "
0.377"	+0.002/-0	0.3775"	✓		Gage Pin	0.377"
47.250"	± 0.015"	47.250"	✓		Read Out	Accimaaster

Measured by: <i>me</i> <i>18/4/10</i>	Audited by: <i>DAS</i> <i>20</i> <i>9-89</i>	Preliminary Approval:
Date: <i>18/02/21</i>	Date: <i>18-04-12</i>	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

